

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002525**Date Inspected:** 13-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun and See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** See Below**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector, M. Paul Stovall, was present at Zhenhua Port Machinery Company (ZPMC) on Changxing Island, Shanghai, China to monitor the Quality Control (QC) functions during the fabrication of the Self Anchored Suspension (SAS) section of the San Francisco/Oakland Bay Bridge.

New Tower Shop

Bay 1

The QA Inspector observed ZPMC personnel performing Submerged Arc Welding (SAW) of fill passes on Tower Skin plate weld joint numbers SSD1-SA16-F/G-6B, ESD1-SA368-16A, and SSD1-SA173-A/K-15B.

The QA Inspector observed ZPMC QC personnel present and monitoring the work. The work observed by this QA Inspector appeared to comply with the contract requirements.

New Tower Shop

Bay 2

The QA Inspector observed ZPMC welding personnel Xue Yian, ID #040634 performing SAW on Tower Skin plate seam weld joint number ESD1-SA227-A/H-16A.

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The QA Inspector observed ZPMC QC personnel present monitoring the work. The work observed by this QA Inspector appeared to comply with the contract requirements.

New Tower Shop

Bay 3

The QA Inspector observed ZPMC personnel remove Internal Diaphragm Plate P775 from the vertical press and replace it with plate P876. The QA Inspector did not witness the press being in use.

OBG Preassembly Bay 3

The QA Inspector observed ZPMC welding personnel Wang Zhenghua, ID #053753, Zhang Feng, ID #048769, and Lv Peng, ID #048617 fit and tack weld WT stiffeners on Side Plates (SP) SP526-001, SP513-001, SP514-001, and SP514-001.

The QA Inspector observed ZPMC personnel using a tracked oxy-acetylene torch to cut bevels on plate material.

The QA Inspector observed ZPMC personnel performing heat straightening on various Side Plates.

OBG Preassembly Bay 4

The QA Inspector observed ZPMC personnel fit and tack weld using the SMAW process, on Diaphragm plates P590 to SA268, for weld joint number of ESD1-SA268-16A. The ZPMC welder is Han Xiaofeng, ID #054467.

The QA Inspector observed ZPMC welder Gu Caihong, ID #053748, perform SAW on Tower Internal Diaphragm plate weld joint number SSD1-SA322-A/B-1B (2B). The QA Inspector monitored the ZPMC QC personnel verifying the WPS parameters on several occasions.

The QA Inspector observed ZPMC personnel performing grinding on the face of completed Complete Joint Penetration (CJP) weld in the rear of the bay.

The QA Inspector observed ZPMC QC personnel present monitoring the work. The work observed by this QA Inspector appeared to comply with the contract requirements.

Summary of Conversations:

The QA Inspector had no significant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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Inspected By: Stovall,Paul

Quality Assurance Inspector

Reviewed By: Hager,Craig

QA Reviewer